

Deriv 55441- close at 0

Work Order ID 55053



Page 1

January 5, 2010 1:52:12 PM

Item ID:	D3798-5	Accept		Setup	Start	
Revision ID:	B				Stop	
Item Name:	Reinforcement					
Star Date:	05/01/2010	Start Qty: 6.00		Cust Item ID:		
Required Date:	15/01/2010	Req'd Qty: 6.00		Customer:		
Reference:						

Approvals:	Process Plan:		Date:	10-1-05	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr								
D3798	B								

100		0.00							
	FLOW WATER JET								
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg D3798								
	Dwg Rev:								
	Prog Rev:								
	2-Debur if necessary								

110	QC2- Inspect parts off machine FAI/FAIB	0.00							
QC	Memo	0.00							
Quality Control									

120	QC8- Inspect parts - second check	0.00							
QC	Memo	0.00							
Quality Control									

=> Siobloc/14

X155

P10-7

10-1-13

16

10-11-13

W/O: 55053		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
10/1/14	#120	Took Qty x1 Part For Q(inspection) template	S	10/1/14	x1	U	S 10/2/14

Part No: D3798-5 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 55053

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Required Date:	15/01/2010	Req'd Qty: 6.00		Customer:		

Reference:

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 HandFinish	Chemical Conversion Coat per QSI005 4.1	0.00							
Hand Finishing	Memo	0.00	BR 10-01-18			(15)	0		
140 QC	QC3- Inspect Part Finish	0.00							
Quality Control	Memo	0.00	ML 10-01-18			115	0		
150 Packaging	Identify as per dwg & Stock Location: 241B	0.00							
Packaging	Memo	0.00				10-118	(15)	0	

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NOTE: Date & initial all entries

Work Order ID 55053

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January 5, 2010 1:52:12 PM

Item ID: D3798-5
Revision ID: B
Item Name: Reinforcement

Accept



Setup Start



Stop



Start Date: 05/01/2010 Start Qty: 6.00



Cust Item ID:

Required Date: 15/01/2010 Req'd Qty: 6.00



Customer:

Reference:

Run Start



Stop



Approvals: Process Plan: Date: Tooling: Date:
QC: Date: SPC (Y/N): Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160 QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/01/28

MF 10-1-19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

January 5, 2010 1:52:18 PM

Page 1

Work Order ID: 55053



Parent Item: D3798-5



Parent Item Name: Reinforcement

Start Date: 05/01/2010

Required Date: 15/01/2010

Comments:

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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M6061T6S.050

Purchased

No

100

sf

110.5716

7.7558

21.



BID-1-13

6061-T6 .050 Sheet

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

110.5715

110791

34.5715

113216

74

17349

2

113216

16

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

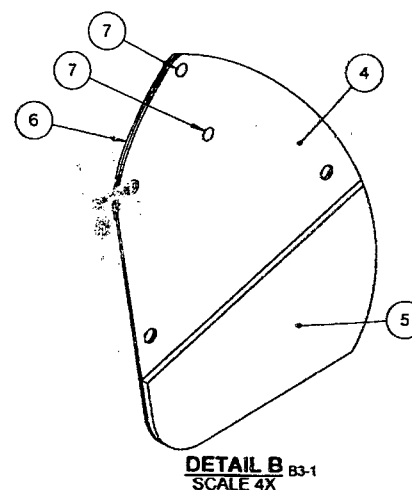
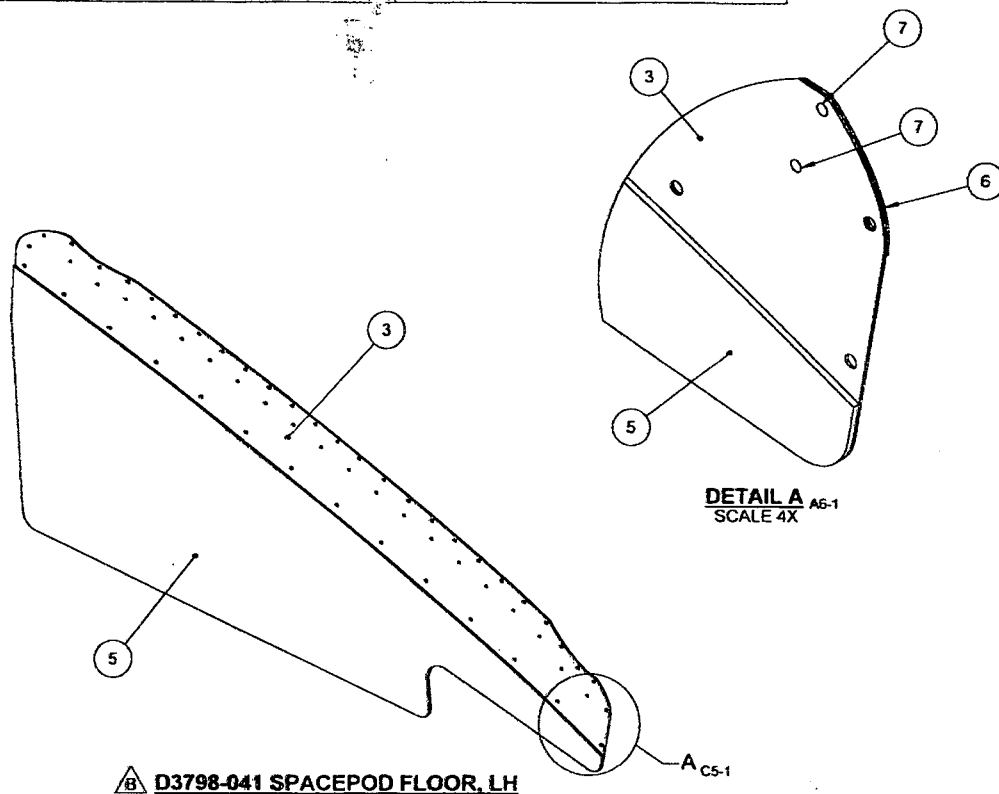
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

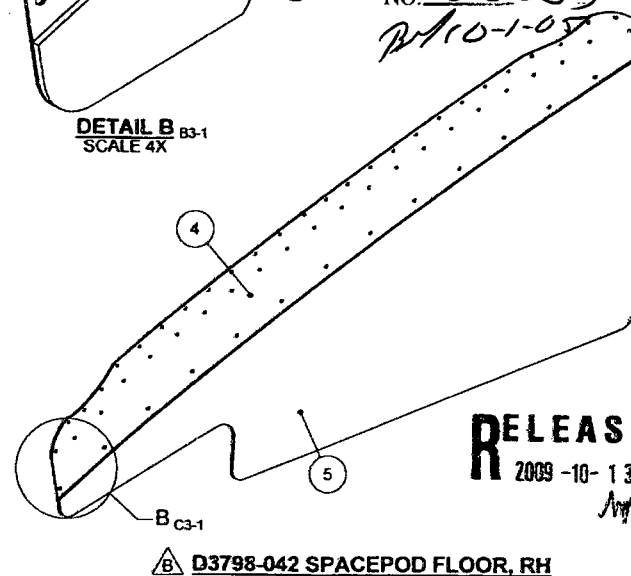
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NOTE: Date & initial all entries

TEM NO.	QTY. -041	QTY. -042	PART NUMBER	DESCRIPTION
1	X		D3798-041	SPACEPOD FLOOR ASSEMBLY, LH
2		X	D3798-042	SPACEPOD FLOOR ASSEMBLY, RH
3	1		D3798-1	SPACEPOD FLOOR
4		1	D3798-2	SPACEPOD FLOOR
5	1	1	D3798-3	SPACEPOD FLOOR FOAM
6	1	1	D3798-5	REINFORCEMENT
7	33	33	MS20426AD4-3	RIVET



SHOW COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER NO. 55053
PA10-1-05



RELEASED
2009-10-13

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3798-041/-042 USING WHITE FINE POINT PERMANENT MARKER
- 7) WEIGHT: D3798-041 - 5.0 lbs
D3798-042 - 5.0 lbs
- 8) ASSEMBLY INSTRUCTIONS
 - RIVET D3798-5 REINFORCEMENT TO D3798-1/-2 SPACEPOD FLOOR USING RIVETS AS INDICATED
 - POWDER COAT PER NOTE 2
 - INSTALL D3798-3 FOAM AS INDICATED USING CONTACT CEMENT. TRIM TO FIT.

B	ADD -5 (SHEET 4); REVISE -041/-042; ADD ASSEMBLY INSTRUCTIONS (NOTE 8)	HS	09.10.08
A	NEW ISSUE	HS	08.10.20
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	09.10.08		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D3798	REV. B
TITLE SPACEPOD FLOOR	SCALE NTS
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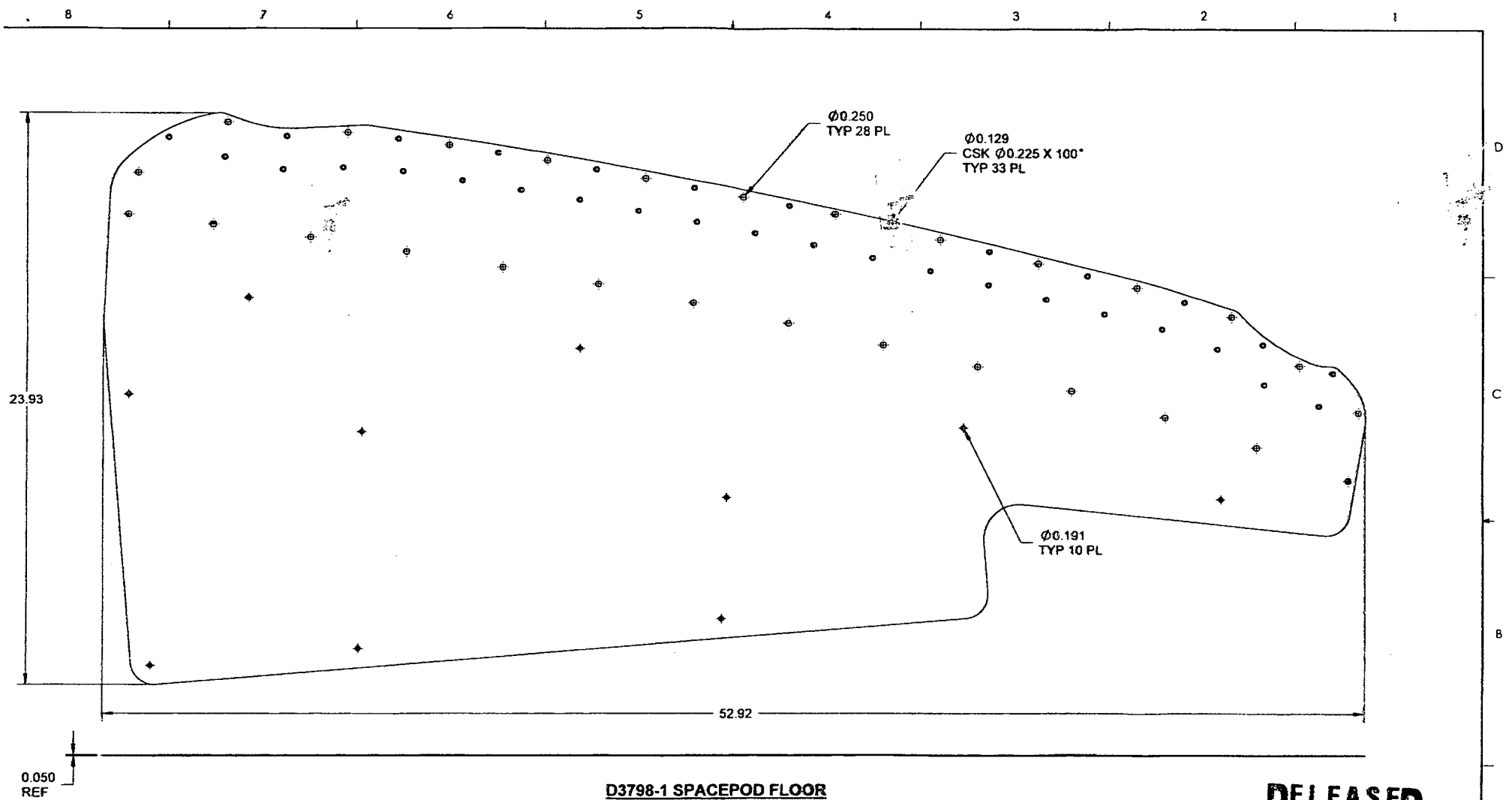
W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



NOTES:

MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.050 THICK
 PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
 REF DART SPEC M6061T6S.050
 FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 UNITS: INCHES UNLESS OTHERWISE NOTED
 BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 IDENTIFICATION: N/A
 WEIGHT: 4.0 lbs
 CONTROL PART PER TEMPLATE DT9432

DESIGN	11/10 55053	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	11/10 55053	DRAWING NO.	REV. B
CHECKED	11/10 55053	D3798	SHEET 2 OF 5
MFG. APPR.	11/10 55053	TITLE	SCALE
APPROVED	11/10 55053	SPACEPOD FLOOR	NTS
DE APPR.	11/10 55053	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED BY THE SUPPLIER ON THE CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DATE	09.10.08		

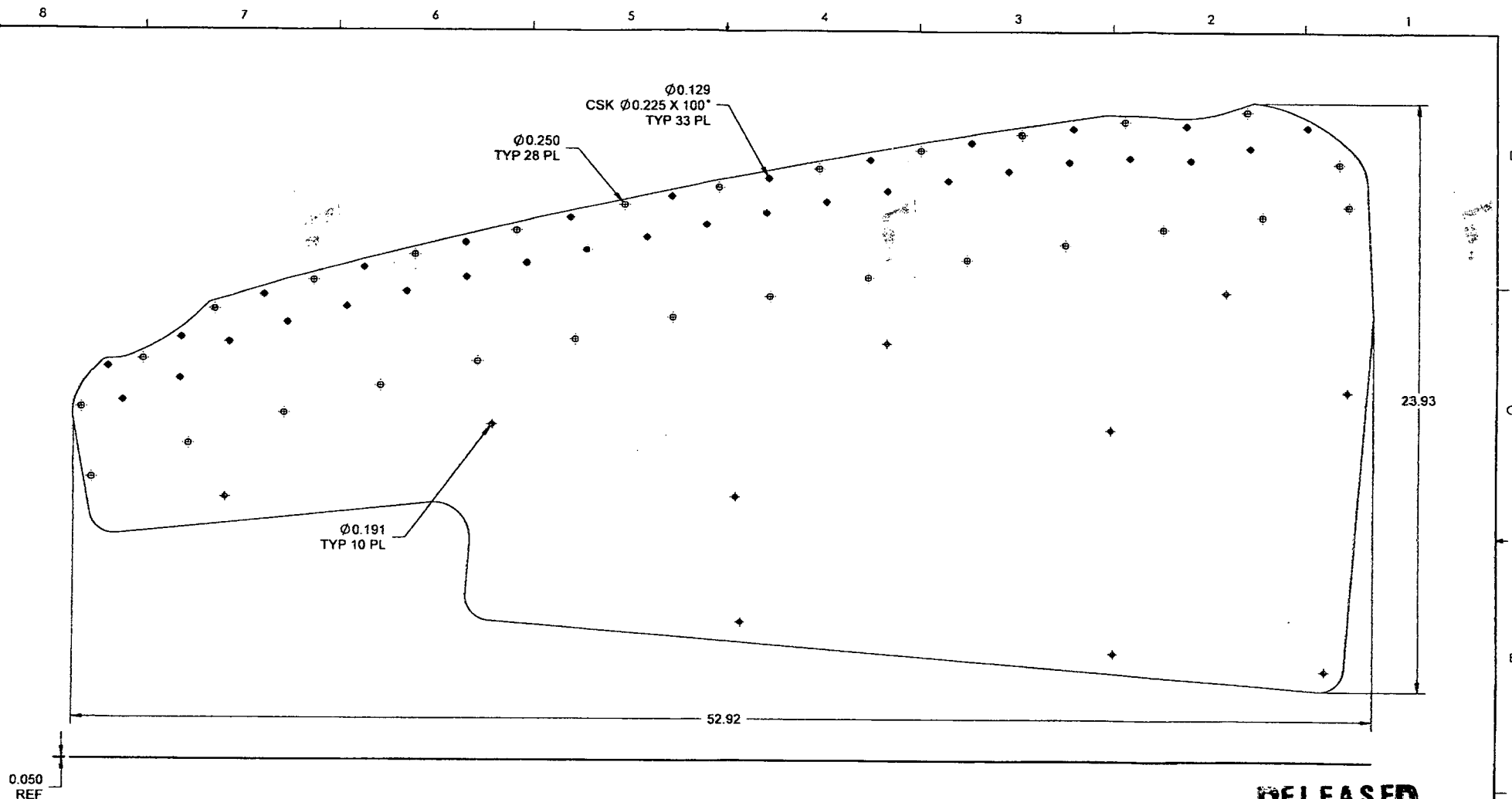
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3798-2 SPACEPOD FLOOR

RELEASED
2009-10-13

W/0 550 53

DESIGN	51	DART AEROSPACE LTD	
DRAWN	51	HAWKESBURY, ONTARIO, CANADA	
CHECKED	51	DRAWING NO. D3798	REV. B
MFG. APPR.	51	SHEET 3 OF 5	
APPROVED	51	TITLE SPACEPOD FLOOR	SCALE NTS
DE APPR.	51	COPYRIGHT © 2008 BY DART AEROSPACE LTD	
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NOTES:
MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.050 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
REF DART SPEC M6061T6S.050
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
UNITS: INCHES UNLESS OTHERWISE NOTED
BREAK SHARP EDGES: 0.005 TO 0.010 MAX
IDENTIFICATION: N/A
WEIGHT: 4.0 lbs
CONTROL PART PER TEMPLATE DT9432

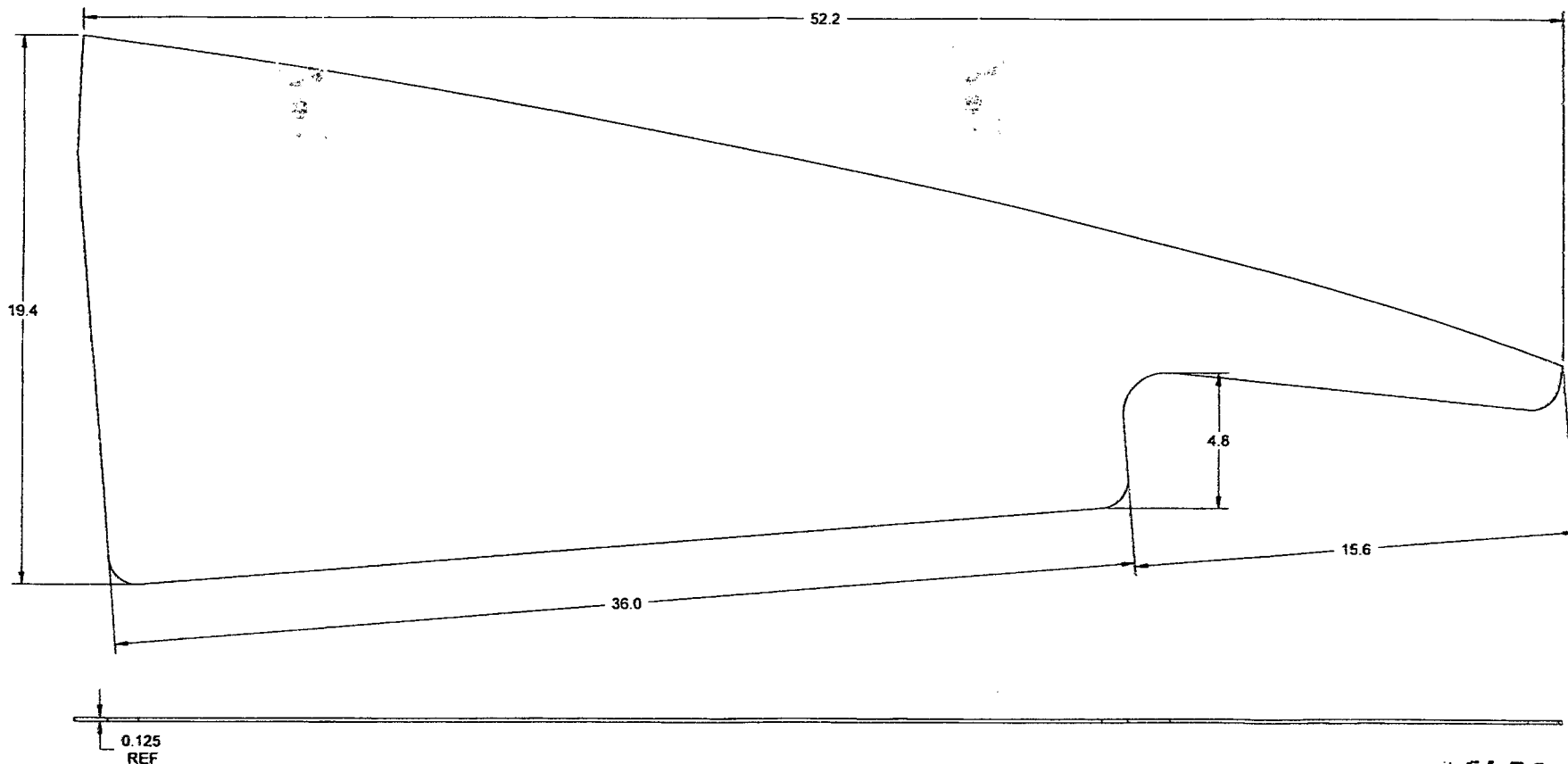
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3798-3 SPACEPOD FLOOR FOAM

RELEASED
2009-10-13

W/0 55053

NOTES:
MATERIAL: BLACK NEOPRENE CLOSED CELL FOAM, 0.125 THICK
REF DART SPEC M-4111N-S.125
FINISH: N/A
TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
UNITS: INCHES UNLESS OTHERWISE NOTED
BREAK SHARP EDGES: N/A
IDENTIFICATION: N/A
WEIGHT: 0.5 lbs
CONTROL PART PER TEMPLATE DT9433

DESIGN	<i>JS</i>	DART AEROSPACE LTD	
DRAWN	<i>JS</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>JS</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>JS</i>	D3798	SHEET 4 OF 5
APPROVED	<i>JS</i>	TITLE	SCALE
DE APPR.	<i>JS</i>	SPACEPOD FLOOR	
DATE	09.10.08	NTS	
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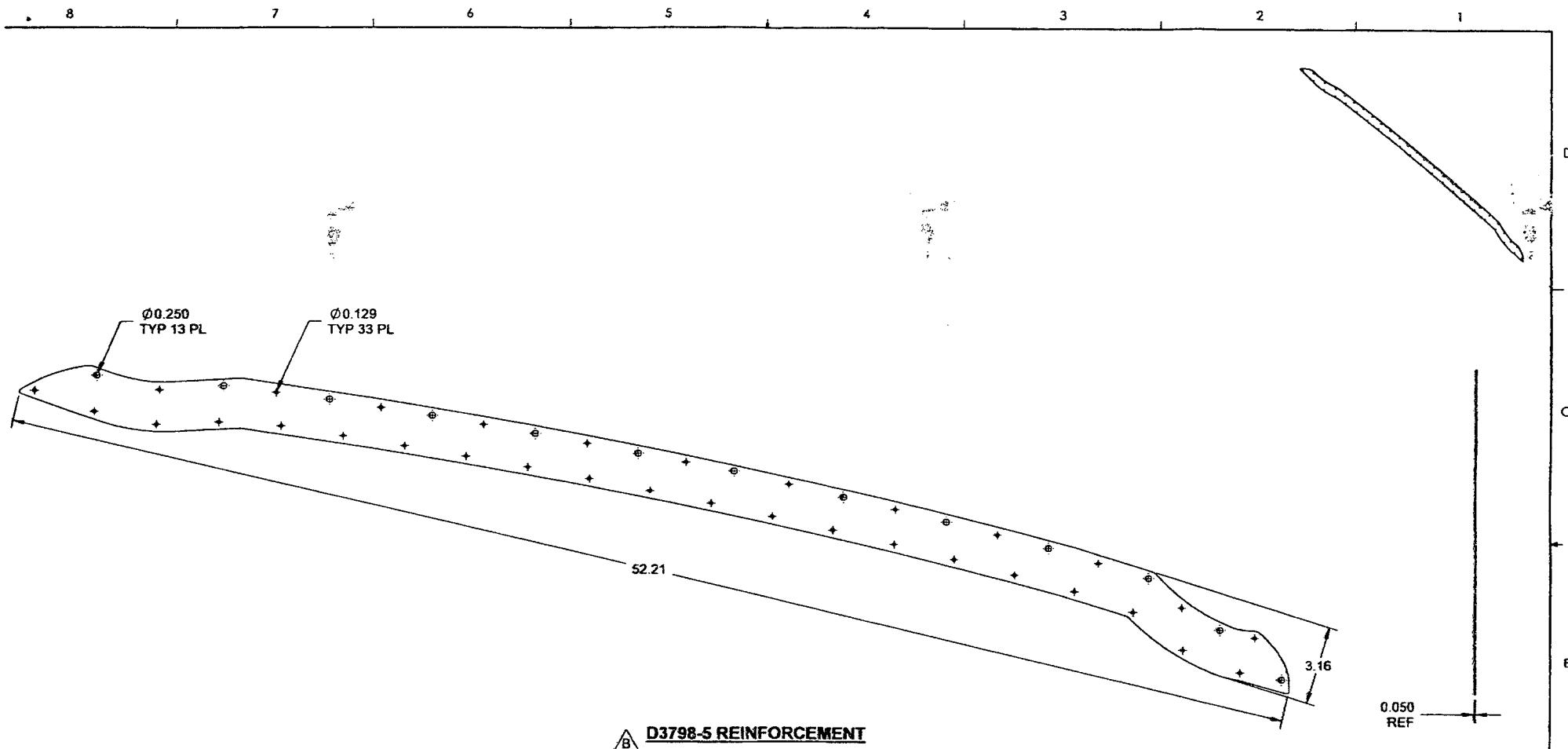
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NOTE: Date & initial all entries



△ D3798-5 REINFORCEMENT

RELEASED
2009-10-13
NP

WLO 55053

NOTES:

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PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
REF DART SPEC M6061T6S.050
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
UNITS: INCHES UNLESS OTHERWISE NOTED
BREAK SHARP EDGES: 0.005 TO 0.010 MAX
IDENTIFICATION: N/A
WEIGHT: 0.5 lbs
CONTROL PART PER TEMPLATE DT9535

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D3798	REV. B
MFG. APPR.		SHEET 5 OF 5	
APPROVED		TITLE SPACEPOD FLOOR	SCALE NTS
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